

# Work Order ID 95208

\*95208\*

Page 1

January-02-13 3:17:21 PM

Item ID: D3645-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Washer

Stop \*NS2\*

Start Date: 1/02/13 Start Qty: 20.00

100  
\*2A\*

Cust Item ID:

Required Date: 1/18/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 13-01-07

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3645

Rev A

100

0.00

\*100\*

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 18765 Purchase Part Number: 90133a017 Supplier: MAC  
MASTER CARR Certificate of conformity is required

CL 13/01/09 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00

\*110\*

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

13/01/10 (100)

120

QC6- Inspect dimensions to drawing

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS  
15  
2-83  
B114

100

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

**\*95208\***

January-02-13 3:17:21 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

\*20\*

\*20\*

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.  
Stamp**

Identify as per dwg & Stock Location: 8 de /

0.00

**\*130\***

### Packaging

## Memo

0.00

### Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

MLS 13-01-15

MF  
13-1-15

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
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		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

# Picklist Print

January-02-13 3:17:20 PM

Page 1

Work Order ID: 95208

Parent Item: D3645-1

Parent Item Name: Washer

Start Date: 1/02/13

Required Date: 1/18/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07.09.24 EC Verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
90133A017 WASHER		Purchased	No			100	Each	0.0000	1	<del>20</del> 100			

1/13/01/10  
(100)

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

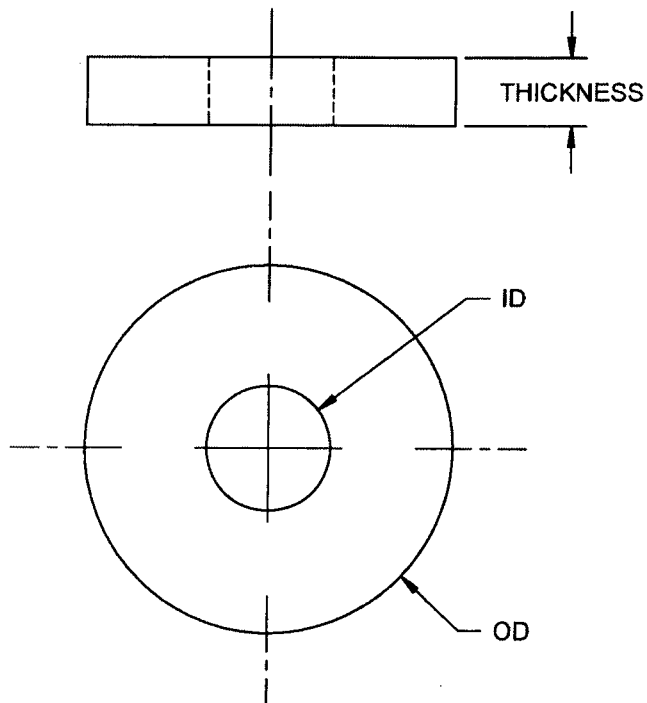
**FAULT CATEGORY**

Landing Gear	General	Other
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		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3645</b>	REV. A SHEET 1 OF 1
DATE <b>07.06.21</b>		TITLE <b>WASHER</b>	SCALE 4:1
REV A	DATE 07.06.21	DESCRIPTION NEW ISSUE	

## SPECIFICATION CONTROL DRAWING



**RELEASED**  
07.08.03



SIC  
RTP  
ENG  
UNCONFIDENTIAL  
SUBJECT TO  
WARRANTY  
NO. 95208 MJS  
13-01-07

P/N	ID	OD	THICKNESS	MATERIAL	SUPPLIER
D3645-1	0.17	0.50	0.09	NEOPRENE	McMASTER-CARR P/N 90133A017

### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO18765

Purchase Order Date 1/09/13

PO Print Date 1/09/13

Page Number 1 of 2

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,  
P.O. BOX 7690  
CHICAGO, IL 60680-7690  
US

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

330 995 5500

Requisition Nbr

Vendor Fax

330 995 9600

Tax Resale Nbr

10127-2607

Vendor Account Nbr

Terms

Net 10

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
@ 1/30/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	90133A017	WASHER	1/11/13 Yes	100.00 Each	FedEx PI collect	\$0.0872	\$8.72
<div><div>CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY</div><div>Special Inst: AS PER DWG D3645 REV. A B95208 MCMaster P/N: 90133A017</div></div>							
2		91732A415 8-32 HELICOIL 0.492"	1/11/13 Yes	2.00 Each	FedEx PI collect	\$4.0400	\$8.08
Deliver To: J-FRANCOIS							
3		91732A720 10-24 HELICOIL 0.475"	1/11/13 Yes	2.00 Each	FedEx PI collect	\$5.9300	\$11.86
Deliver To: J-FRANCOIS							
4		5078K73 6" DUCTING	1/11/13 Yes	3.00 Each	FedEx PI collect	\$11.5300	\$34.59

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required - YES NO

Change Nbr: 1

Change Date: 1/09/13





100 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada  
Attention: J-Francois  
J-Luc

Purchase Order  
PO18765

Order Placed By  
Chantal Lavoie

McMaster-Carr Number  
5792402-02

01/09/2013

		Ordered		Shipped			
Line	Description						
1	90133A017 Neoprene Rubber Washer, No. 10 Screw Size, 1/2" OD, .093" Thick, Packs of 100	1	Pack	1		2 - 621 - 02	04 - 41 A017 1 PK 1
	Unit Price:	\$8.72					
	Extended Price:	\$8.72					
2	91732A415 18-8 Stainless Steel Standard Helical Insert, 8-32 Internal Thread, .492" Length, MS122-239, Packs of 5	2	Packs	2		2 - 136	2
	Unit Price:	\$4.04					
	Extended Price:	\$8.08					
4	5078K73 Galvanized Steel Spiral Duct, 6" Diameter, 2' Length	3	Each	3		8 - 77	
	Unit Price:	\$11.53					
	Extended Price:	\$34.59					
5	5078K48 6" Diameter Connector Sleeve for, Galvanized Steel Spiral Duct	3	Each	3		8 - 117	
	Unit Price:	\$6.80					
	Extended Price:	\$20.40					

Dart Aerospace Ltd

EXP  
INV



Lg  
38x16x16



FW  
01/1  
10:  
351  
Cyc